

Work Order ID 151642

Wednesday, October 05, 2016 1:53:13 PM

151642

Page 1

Item ID: D5061-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Wearplate
 Start Date: 10/5/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: 16/10/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5061	A								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.05							
FLOW CNC Waterjet	1- Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Debur if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.01							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.01							
Quality Control									

DAS 38 9-89
OCT 06 2016

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE Memo Form joggle as per dwg.	0.10 0.04			DAS 30 9-89	(4)			NOV 02 2016
150 *150* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				4			DAS 38 9-89 NOV 02 2016
160 *160* Large Fab Large Fab	Large Fab Memo Weld hard surface as per QSI 004 and Dwg D5061 2059 Hardcoat Rod <u>M130175</u>	0.00 0.17				(4)		DYC 16/11/16	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
186	QC3- Inspect Part Finish	0.00							DAS 38 9-89
186						4			
QC	Memo	0.01							
Quality Control									NOV 24 2016
190	Identify as per dwg & Stock Location	0.00							
190	Packaging								
Packaging	Memo	0.01							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89

NOV 24 2016

Picklist Print

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Work Order ID: 151642

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Parent Item: D5061-1

D5061-1

Parent Item Name: Fwd Wearplate

Start Date: 10/5/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.02.13 NEW ISSUE DD VERF:JLM
REV:B 14.03.12 rev.A10 DD VERF:JLM
14.04.21 rev.A DD VERF:JLM

IPP
IPP REV:c

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No			sf	225.7240		15.07368			

M304S18GA

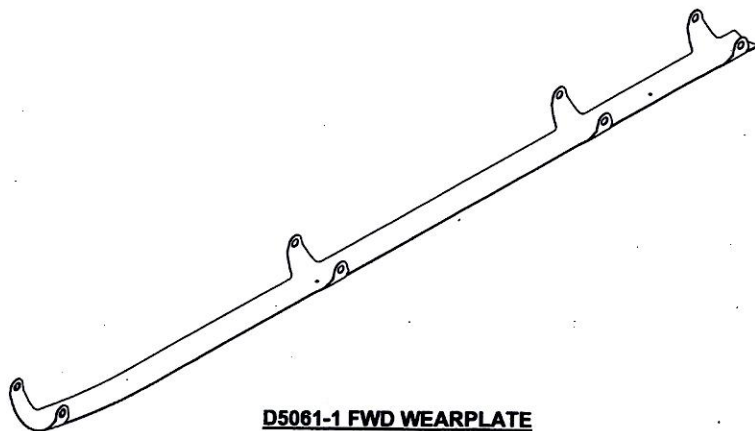
304/316 .050 Sheet

02/16/10/05

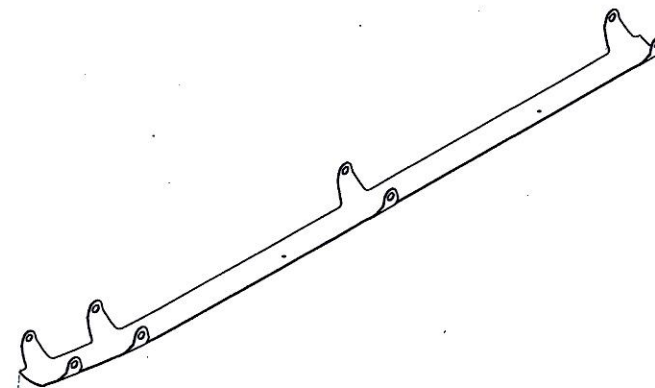
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	96.824	
M133328	55.224	
M133587	0.7	
M134824	20.7	
M134982	20.2	
M135779	120	
MAT20	8.9	
M134580	8.9	

135779

13



D5061-1 FWD WEARPLATE



D5061-3 AFT WEARPLATE

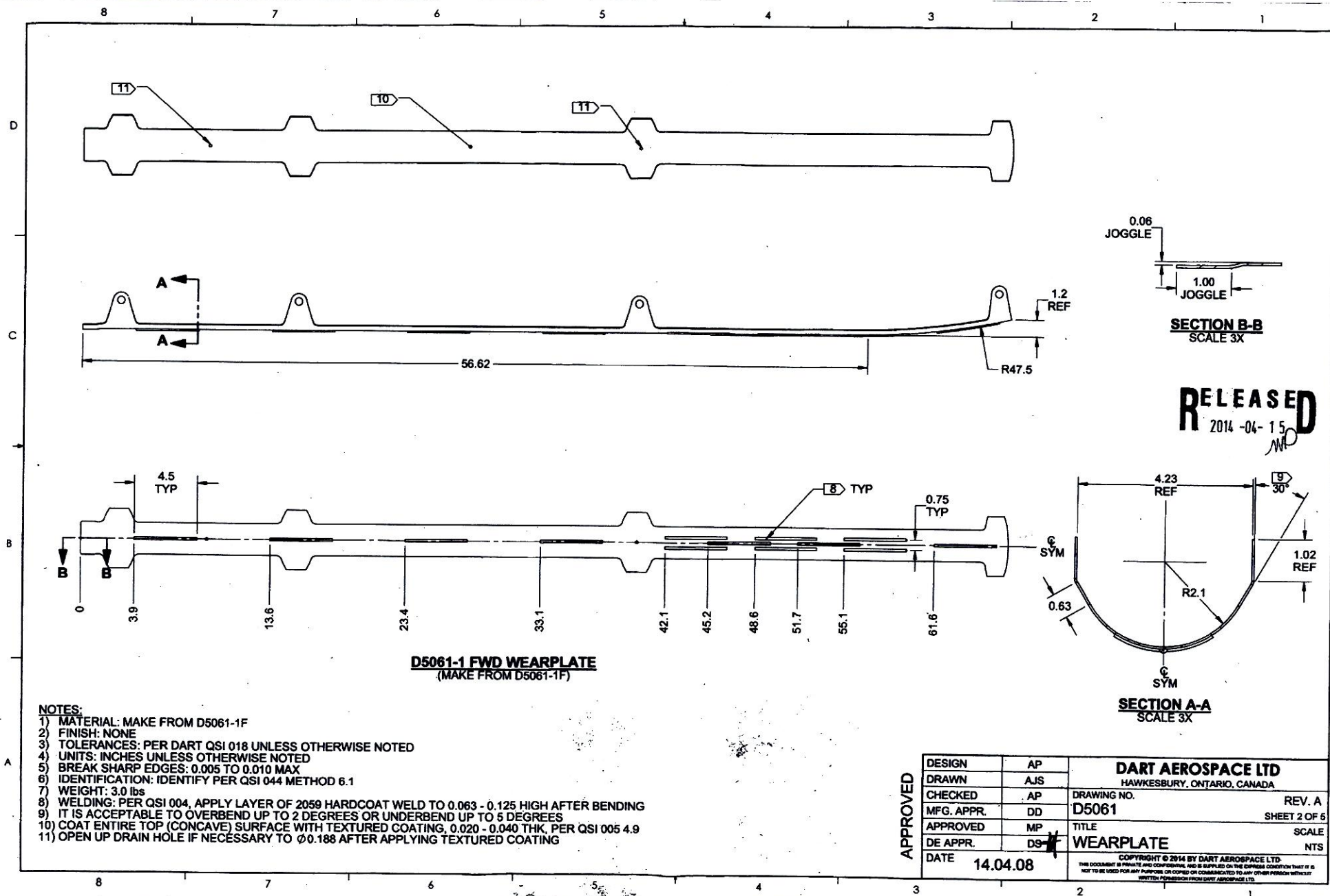
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1316A2

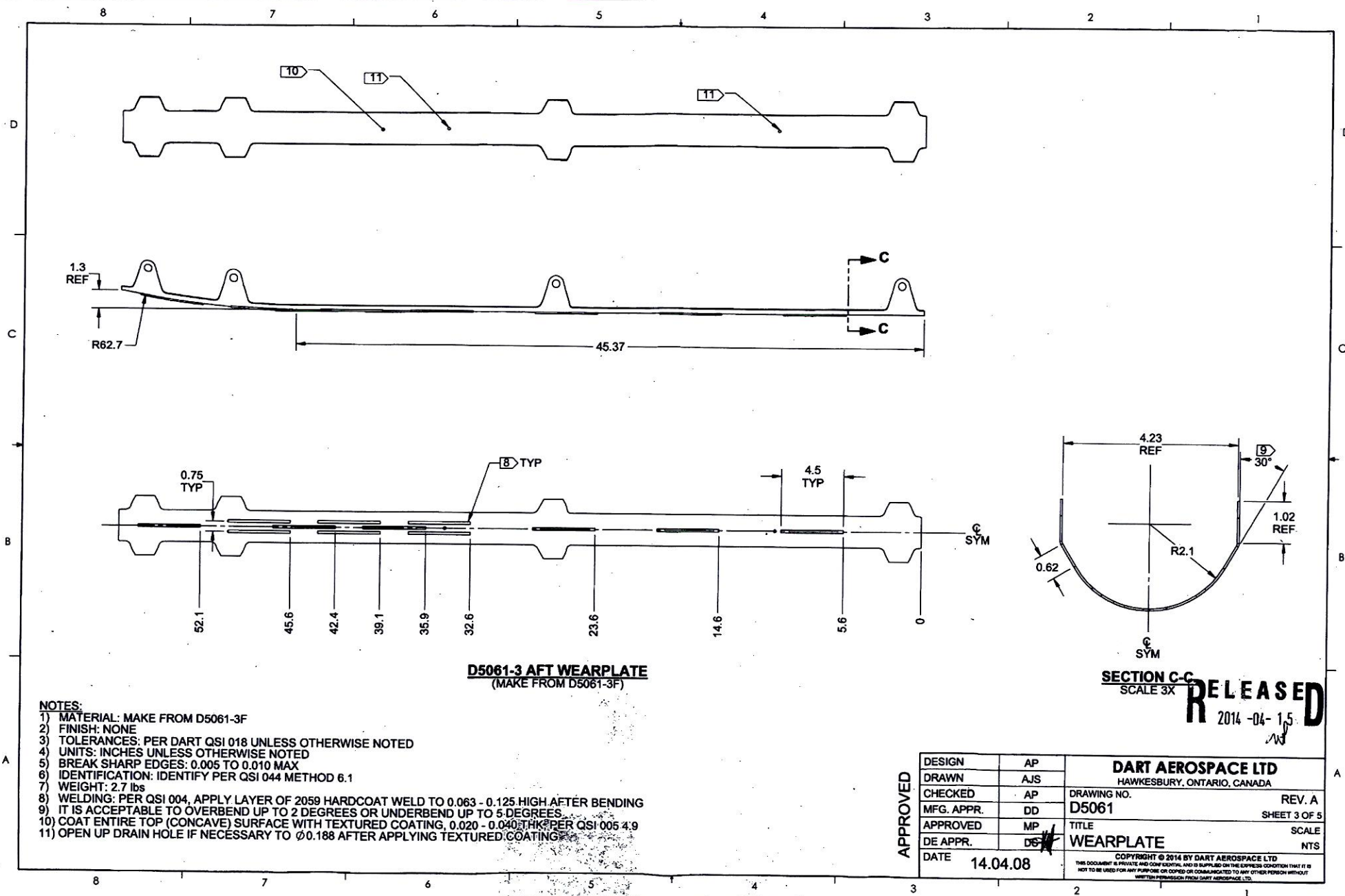
28m 16/10/05

RELEASED
2014-04-15
WID

APPROVED	REV	NEW ISSUE	AP	14.04.08
	DESIGN	AP	BY	DATE
	DRAWN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP		
	MFG. APPR.	DD	DRAWING NO.	REV. A
	APPROVED	MP	TITLE	SHEET 1 OF 5
DE APPR.	D8	WEARPLATE	SCALE	
DATE	14.04.08	NTS		

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NOTES:

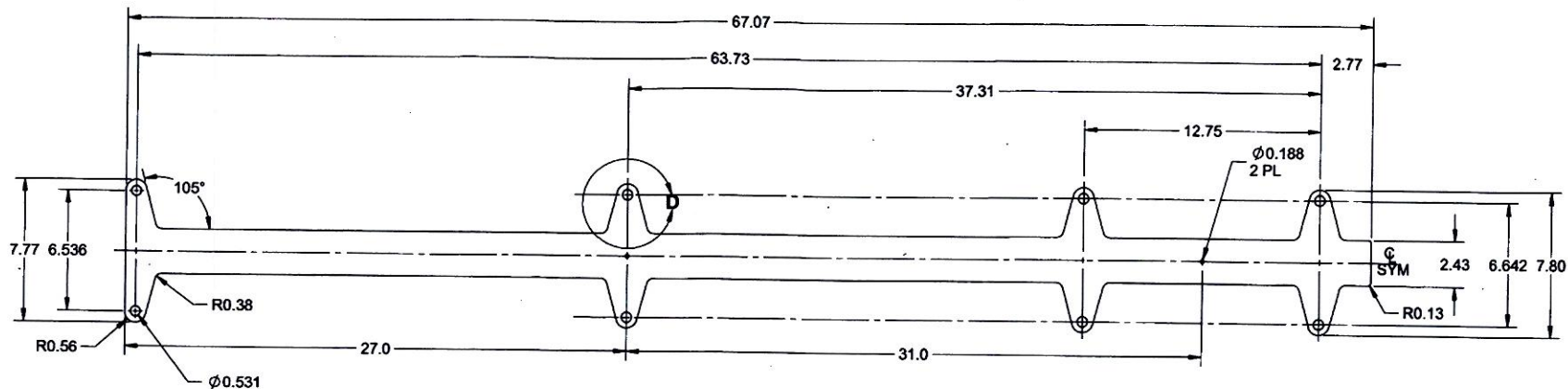
- 1) MATERIAL: MAKE FROM D5061-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.7 lbs
- 8) WELDING: PER QSI 004, APPLY LAYER OF 2059 HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) IT IS ACCEPTABLE TO OVERBEND UP TO 2 DEGREES OR UNDERBEND UP TO 5 DEGREES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THK PER QSI 005 4.9
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING TEXTURED COATING

APPROVED

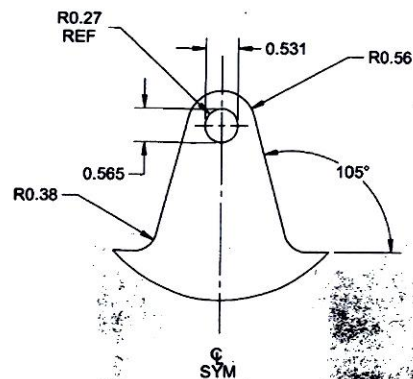
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	AP	DRAWING NO. D5061
MFG. APPR.	DD	REV. A
APPROVED	MP	SHEET 3 OF 5
DE APPR.	DS	TITLE WEARPLATE
DATE	14.04.08	SCALE NTS

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2014-04-15



D5061-1F FWD WEARPLATE



DETAIL D
SCALE 3X
3 PL

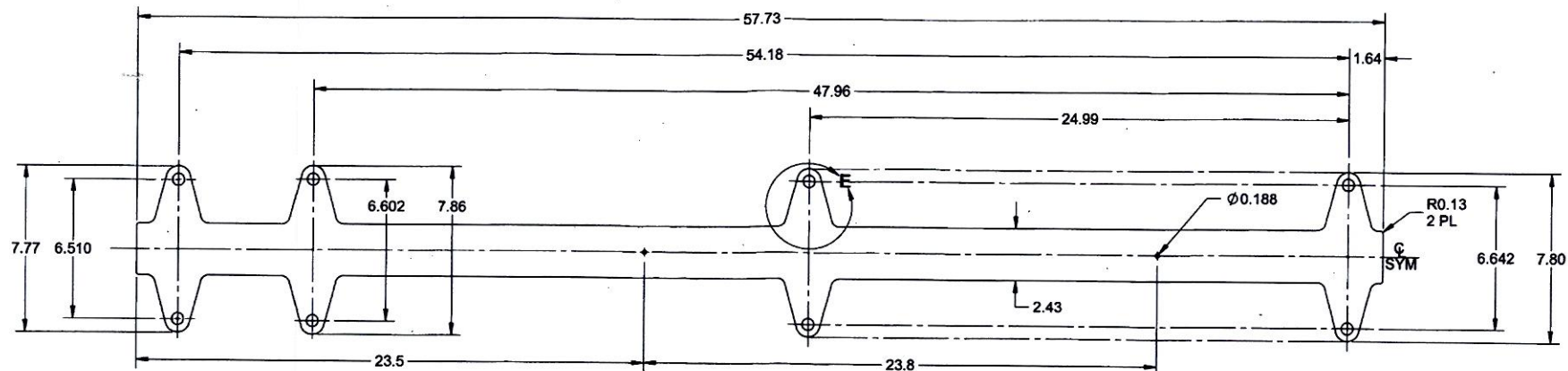
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

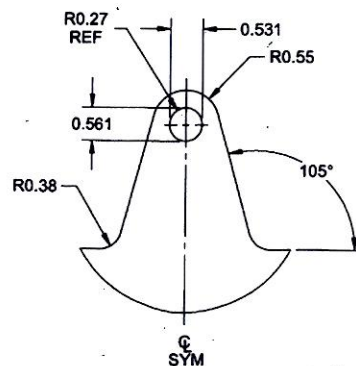
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D5061-3F AFT WEARPLATE



DETAIL E
SCALE 3X
4 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5061	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	14.04.08	COPYRIGHT © 2014 BY DART AEROSPACE LTD	

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